



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5735-5
Job Sheet 203336

Accounting Job RD19-1069-01



Part No: D5735-5

Job Qty: 1 pcs

Part Name: AFT Wearplate



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1206 DWG D5735/DSK193-1F Rev.A/A IPP Rev. A 19.11.08 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 11/11/19 AUTH NO

RELEASED 9-89 DATE 19-11-26

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1		11/29/19	0.17	0.25	Waterjet - Flow		JRB 11/20/19
		pcs							
110	QC 2	1		11/29/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S233327

Part: D5735-5

Job No: 203336

Serial No/Batch: S233327

Revision: U/R A & A

Inspector:

Exp Date:

Instructions:

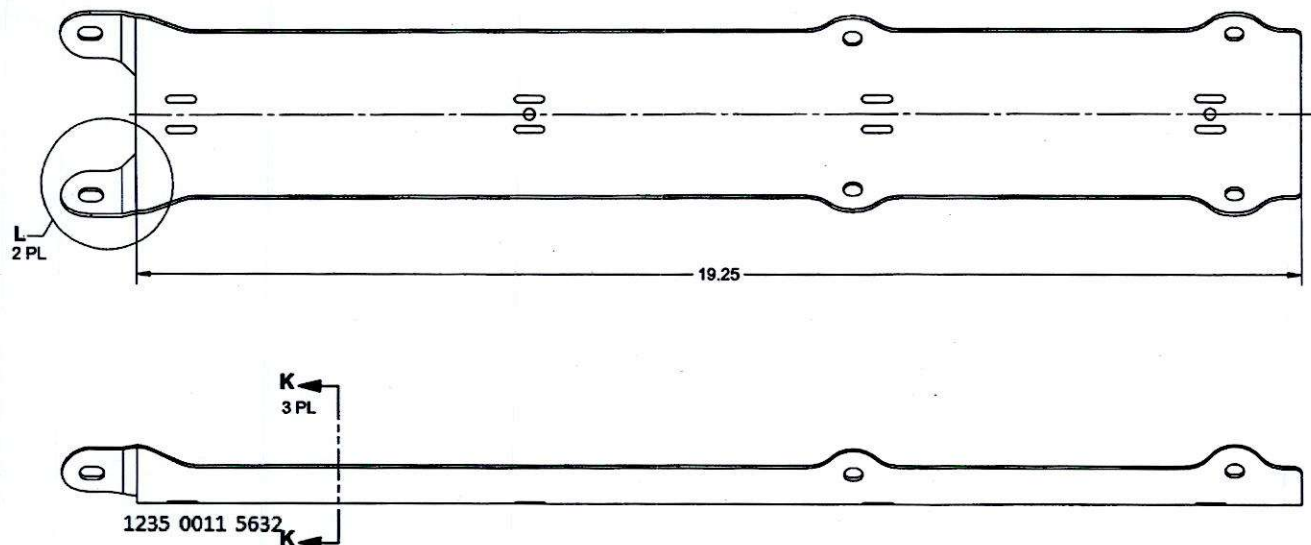
Date: 11/20/19

Plex 11/15/19 9:59 AM Dart.lajeunesse.marie

120 QC 8	1 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/20/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS 40 NOV 20 2019 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	DAS 30 9-89 NOV 25 2019
130 Small Fab - Brake NC - B4B	1 pcs	11/29/19	0.25 0.17	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 NOV 25 2019 9-89
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

	Packaging 3 - 4 - B4B			
	Packaging 3 - 5 - B4B			
	Packaging 3 - 6 - B4B			
	Packaging 3 - 7 - B4B			
	Packaging 3 - 8 - B4B			
	Packaging 3 - 9 - B4B			
	Packaging 3 - 10 - B4B			
	Packaging 3 - 11 - B4B			
	Packaging 3 - 12 - B4B	62		
	Packaging 3 - 13 - B4B			
	Packaging 3 - 14 - B4B			
	Packaging 3 - 15 - B4B			
	Packaging 3 - 16 - B4B			
	Packaging 3 - 17 - B4B			
	Packaging 3 - 18 - B4B			
	Packaging 3 - 19 - B4B			
	Packaging 3 - 20 - B4B			
	Packaging 3 - 21 - B4B			
	Packaging 3 - 22 - B4B			
	Packaging 3 - 23 - B4B			
	Packaging 3 - 24 - B4B			
	Packaging 3 - 25 - B4B			
	Packaging 3 - 26 - B4B			
	Packaging 3 - 27 - B4B			
	Packaging 3 - 28 - B4B			
	Packaging 3 - 29 - B4B			
	Packaging 3 - 30 - B4B			
	Packaging 3 - 31 - B4B			
	Packaging 3 - 32 - B4B			
	Packaging 3 - 33 - B4B			
	Packaging 3 - 34 - B4B			
	Packaging 3 - 35 - B4B			
	Packaging 3 - 36 - B4B			
	160 QC 21 - SA	1 pcs	11/29/19 0.00 0.00	
			QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	
Part Op 100 - 1-Cut DSK193-5F as per dwg prog rev: <u>A</u> dwg rev: <u>A</u> 2-Deburr if required Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Form as per dwg D5735 140 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: <u>42A21</u> 160 - QC21- Final Inspection - Work Order Release				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1 sf (1 ea)	100-Waterjet - Flow - 1	S207056
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	266	0
Part Specifications				
Specifications could not be found.				

NOV 27 2019



D5735-5 AFT WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203336 MCT
19-11-15

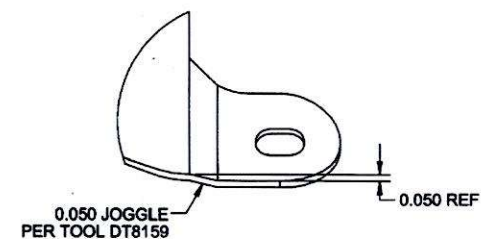
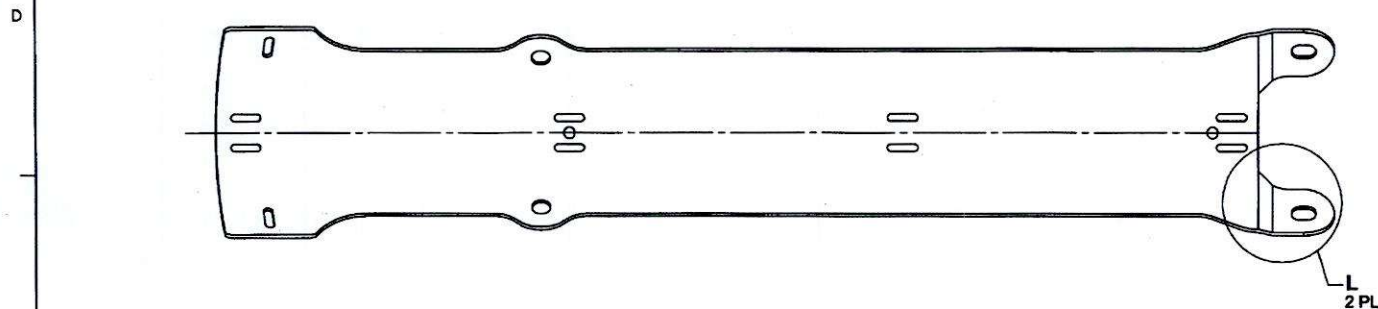
UNDER REVIEW
URF 19-1206 19.11.07 (VM)

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DSK193-5F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.10 lbs

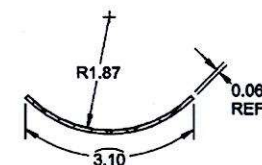
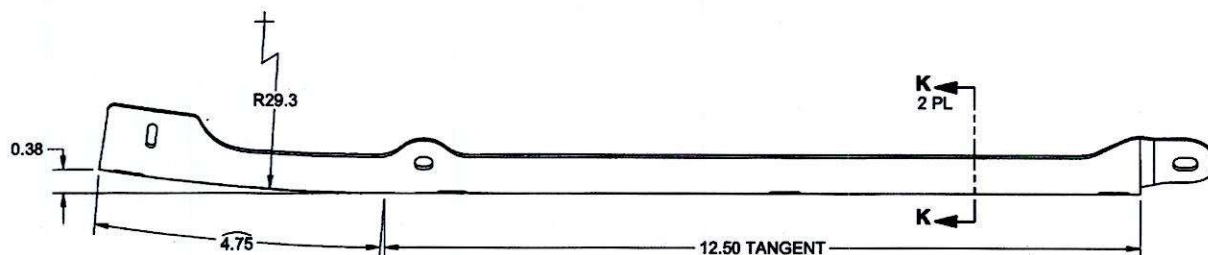
APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5735	SHEET 11 OF 13
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
DATE	19.08.20	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



DETAIL L



SECTION K-K

D5735-1 FWD WEARPLATE

UNDER REVIEW

URF 19-1206 19.11.07 (VM)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DSK193-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.02 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5735	SHEET 9 OF 13
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
DATE	19.08.20	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 203336
Description: Aft wear plate		Part Number: DSK193-5
Inspection Dwg: DSK193	Rev: A	Page 1 of 1

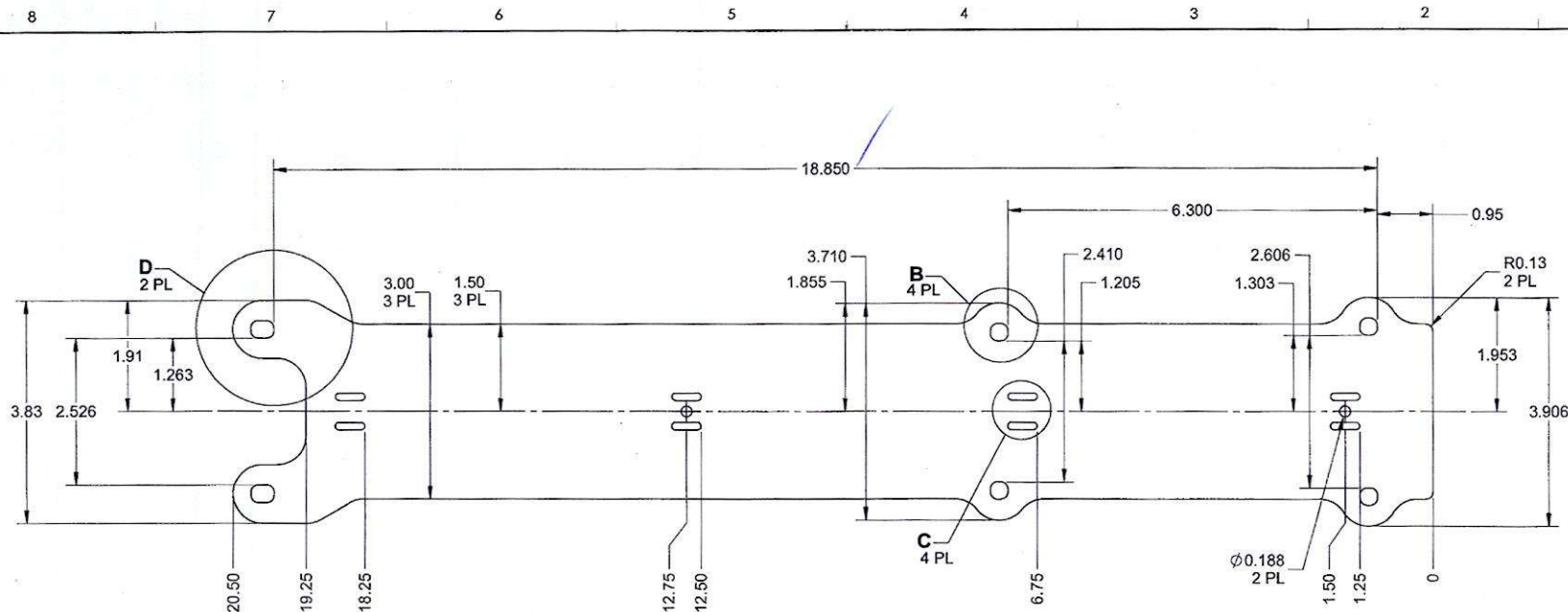
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.188	+0.005 -0.001	0.190	✓			
3.83	+/- 0.030	3.84				
2.526	+/- 0.010	2.527				
1.91	+/- 0.030	1.92				
1.263	+/- 0.010	1.265				
R0.50	+/- 0.	R0.50				
0.400	+/- 0.010	0.403				
0.300	+/- 0.010	0.302				
1.000	+/- 0.010	1.003				
R0.13	+/-	R0.13				
1.25	+/- 0.030	1.26				
3.00	+/- 0.030	3.02				
1.50	+/- 0.030	1.51				
18.850	+/- 0.010	18.851				
1.855	+/- 0.010	1.856				
3.710	+/- 0.010	3.712				
R0.50	+/-	R0.50				
0.300	+/- 0.010	0.303				
R0.13	+/-	R0.13				
0.300	+/- 0.010	0.303				
2.410	+/- 0.010	2.412				
1.205	+/- 0.010	1.205				
6.300	+/- 0.010	6.303				
1.303	+/- 0.010	1.304				
2.606	+/- 0.010	2.607				
0.95	+/- 0.030	0.95				
R0.13	+/-	R0.13				
1.953	+/- 0.010	1.954				
3.906	+/- 0.010	3.907				

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



DSK193-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.09 lbs
- 8) USE TO MAKE D5735-5

RELEASED
2019-11-13

DESIGN	ZF	DART AEROSPACE USA, INC.	
DRAWN	ZF	HILLSBORO, OR	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	DSK193	SHEET 3 OF 5
APPROVED	NO <i>NP</i>	TITLE	SCALE
DE APPR.	N/A	WEARPLATE FLAT PATTERN	NTS
DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	